



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2891-1
Job Sheet 186553



Part No: D2891-1

Job Qty: 10 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 12/28/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified: DD IPP Rev:E 11.08.04 as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis S144708	10 pcs	12/28/18	12/28/18	0.41	8.20	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	10 pcs	12/28/18	12/28/18	0.00	0.00	QC 2 - 1		Kt 2019-02-11 Kt 2019-02-11
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S152245



Part: D2891-1

Job No: 186553

Serial No/Batch: S152245

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/11/19

120	QC 8	10 pcs	12/28/18	0.00 0.00	QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 8 - 12	m/19/02/12
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
130	Crosstubes - 2 - B4B	10 pcs	12/28/18	0.00 0.47	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	m/19.2-19
					Crosstubes - 5 - B4B	
					Crosstubes - 6 - B4B	
140	QC 3	10 pcs	12/28/18	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
170	Packaging 3-1 - Stock - B4B	10 pcs	12/28/18	0.00 0.00	Packaging 3 - 1 - B4B	DAS 40 9-89
					Packaging 3 - 2 - B4B	DAS 9 3-89
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	

19.02.20

					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	LG050 : AS 19-2-28
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	10 pcs	12/28/18	0.00 0.00	QC 21 - SA - 21	DAC 21 MAR 01 2019
					QC 21 - SA - 70	
Part Op 100 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. 133652 exp: 19/4 140 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ LOCATION : LG052 LG050 180 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
DSK076	D2891-1 Turning Detail	5 Ea (.5 ea)	100-HAAS 4 Axis			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-HAAS 4 Axis	DSK076	5	10	0		

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040		
5	2.250 Support	0.010Inches ± 0.000	0.000 0.010		
6	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
7	2.250 Support	0.290Inches ± 0.000	0.000 0.290		
8	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
9	2.250 Support	0.454Inches ± 0.000	0.000 0.454		
10	2.250 Support	2.779Inches ± 0.000	0.000 2.779		
11	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
12	2.250 Support	1.002Inches ± 0.000	0.000 1.002		
13	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
14	2.250 Support	0.257Inches ± 0.000	0.000 0.257		
15	2.250 Support	1.663Inches ± 0.000	0.000 1.663		
16	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022		

Plex 1/22/19 11:34 AM Dart.Hadley.Shannon



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D2891-1**Job Sheet 186553****Part No:** D2891-1**Job Qty:** 10 ea**Part Name:** Support 2.25**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/16/18**Job Tracking No:****Due Date:** 12/28/18**Created By:** Jesse White**Type:** Stock**Description:** SIOP

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified: DD IPP Rev:E 11.08.04 as per dwg rev.B DD verf:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/28/18	0.00	0.00	Start Up Machining-1		
100	CNC Vertical Machining	10 pcs		12/28/18	0.41	8.20	HAAS1-2		
110	QC	10 pcs		12/28/18	0.00	0.00	QC2 Machining-1		
120	QC	10 pcs		12/28/18	0.00	0.00	QC8 Machining-1		
130	Crosstubes	10 pcs		12/28/18	0.00	0.47	Crosstubes-2		
140	QC	10 pcs		12/28/18	0.00	0.00	QC3		
170	Packaging	10 pcs		12/28/18	0.00	0.00	Packaging3-1		
180	QC21-SA	10 Ea		12/28/18	0.00	0.00	QC21		

Part Op 100 - 1-Machine as per Folio FA046

Descriptions: **130** - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time.

170 - LOCATION : LG052**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK076	5	5	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Clpsed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
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16	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022		

Plex 11/16/18 3:41 PM dart.white.jesse

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Clpsed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.130	0.130	0.130	0.130	0.130
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.141	0.140	0.140	0.140	0.140
AI	0.454	0.474		0.465	0.465	0.465	0.465	0.465
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.042	1.040	1.036	1.037	1.040
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.257	0.257	0.257	0.257	0.257
AO	1.663	1.683		1.673	1.673	1.673	1.673	1.673
AP	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

DAS

Measured by: KT 1	Date: 2019-02-10
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Audited by: 9-89	Date: 19/02/12
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.130	0.130	0.130	0.130	0.130
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.135	0.135	0.135	0.135	0.135
AI	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.033	1.039	1.037	1.034	1.036
AM	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AN	0.257	0.262		0.257	0.257	0.257	0.257	0.257
AO	1.663	1.683		1.673	1.673	1.673	1.673	1.673
AP	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>[Signature]</i>	Date: 2019-02-10
Audited by: <i>[Signature]</i>	Date: 19/02/12
Preliminary Approval:	Date:

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